

Work Order ID 71581

Wednesday, July 06, 2011 1:24:54 PM



Page 1

Item ID: D3535-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 7/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals: Process Plan: C2 Date: 11/07/06 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B11-7-7

354 . 046

(13)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-7-7

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/11

(Y13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71581

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Item ID: D3535-23	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Wearshoe				
Start Date: 7/6/2011	Start Qty: 12.00		Cust Item ID:	
Required Date: 7/20/2011	Req'd Qty: 12.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-23								

140	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:45								
	FINISH TIME: 11:15								

M 115128 32001

SB 11/7/12





8/1/12

12X8 m/d 11/07/12

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3535-23 PAR #: N/A Fault Category: Small Part NCR: Yes No DQA: 11 Date: 11.07.13
 Resolution: scrap Disposition: scrap QA: N/C Closed: 11/09/13

NCR: <u>71581</u>		WORK ORDER NON-CONFORMANCE (NCR) #22.71						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/07/13	130	found 1 part with a default cut in it L.C. w/s moves work Process still in the Process.		Scrap & destroy no Resline Qty = 1	SA 11/07/13	 11/09/13	 03/11/13	 11/09/13

NOTE: Date & initial all entries

Work Order ID 71581

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Item ID: D3535-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 7/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 BL 11-7-12

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

F-P 21

12x Ø M-1 11/07/12

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11-7-12

MF 11-07-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 1:24:51 PM

Page 1

Work Order ID: 71581

Parent Item: D3535-23

Parent Item Name: Wearshoe




Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	134.1630	1.3615	17.19789			

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

134.163

116623

0.2

117550

9.363

117933

124.6

117933

18.
B11-7-7
(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	71581
Description: Wearshoe		Part Number:	D3535-23
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.885	✓		V	
2.000	+/-0.010	2.00	✓		V	
4.750	+/-0.010	4.756	✓		V	
9.500	+/-0.010	9.506	✓		T B01	
14.250	+/-0.010	14.250	✓		T	
17.750	+/-0.010	17.756	✓		T	
23.140	+/-0.010	23.146	✓		T	
28.530	+/-0.010	28.536	✓		T	
33.920	+/-0.010	33.926	✓		T	
39.310	+/-0.010	39.316	✓		T	
44.700	+/-0.010	44.706	✓		T	
48.200	+/-0.010	48.206	✓		T	
52.850	+/-0.010	52.856	✓		T	
Ø0.188	+0.005/-0.001	.192	✓		V B02	
48.00	+/-0.030	48.00	✓		T	
39.00	+/-0.030	39.00	✓		T	
32.00	+/-0.030	32.00	✓		T	
24.00	+/-0.030	24.00	✓		T	
16.00	+/-0.030	16.00	✓		T	
8.00	+/-0.030	8.00	✓		T	
6.00	+/-0.030	6.00	✓		T	
0.300	+/-0.010	.304	✓		V	
0.300	+/-0.010	.303	✓		V	
0.038	+/-0.010	.034	✓		V	

Measured by:	B
Date:	11-7-7

Audited by:	S
Date:	11/7/11

Prototype Approval:	N/A
Date:	N/A

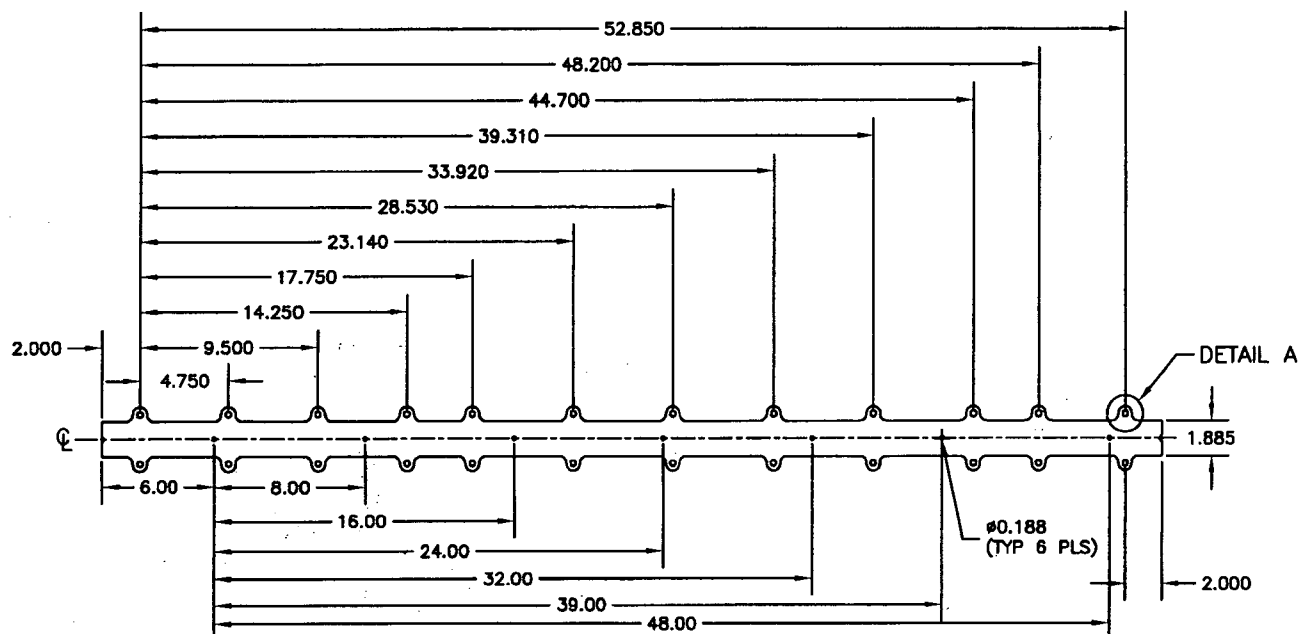
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	JA

DART

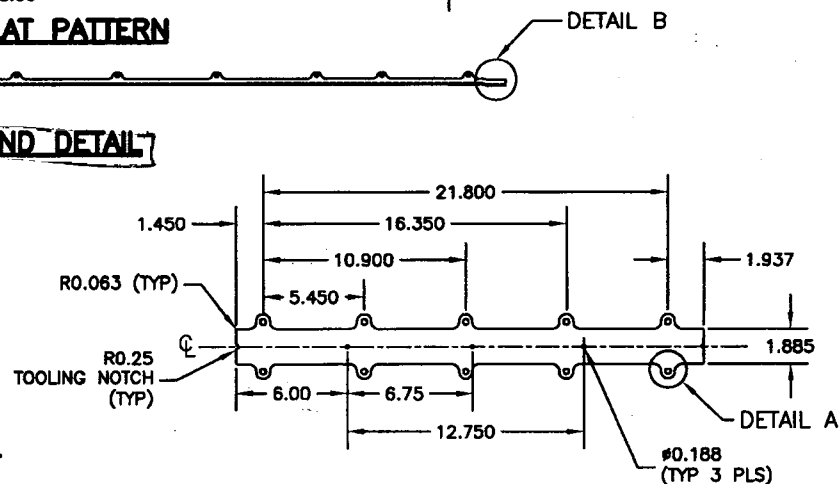
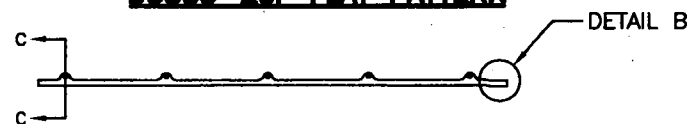
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 3 OF 7
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10

RELEASED

07.04.24

**D3535-23F FLAT PATTERN**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71581

D3535-23 BEND DETAIL**D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION